Work Order ID 108396 *108396*

October-17-13 1:23:47 PM

Item ID:	D2704		**Accept**	*N900040100*	**Setup** Start *NS1* Stop *NS2*
Revision ID:					
Item Name:	Cross Brace				
Start Date:	10/17/13	**Start Qty:** 1.00	*1*	**Cust Item ID:**	
Required Date:	10/17/13	**Req'd Qty:** 1.00	*1*	**Customer:**	
Reference:					**Run** Start *NR1* Stop *NR2*

SW

Approvals: **Process Plan:** MLS **Date:** 13-10-22 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2704	Rev A1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Brake NC Brake NC	NC BRAKE **Memo** Punch tube 304/316 with 2B finish Deburr - 28.17	0.00 0.00				5	SAD	13-10-30	
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	SHP 13 10.30			S			
120 *120* Powdercoat Powder Coating	White Gloss(Ref 4.3.5.2) per QSI005 4.3-Steel M126824. **Memo** START TIME: 3:00 OVEN TEMPERATURE: 400° FINISH TIME: 3:30	0.00 0.00				5	ø	13-10-31	DAS 34 9-89

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________ Part No. ____________ NCR No. ____________	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 108396 *108396*

October-17-13 1:23:47 PM

Item ID:	D2704			**Accept**	*N900040100*
Revision ID:				**Setup Start**	*NS1*
Item Name:	Cross Brace			**Stop**	*NS2*
Start Date:	10/17/13	**Start Qty:** 1.00	*1*	**Cust Item ID:**	
Required Date:	10/17/13	**Req'd Qty:** 1.00	*1*	**Customer:**	
Reference:					

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00 DAS 27 9-89 13 11 01				5			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: ST253 Memo	0.00 0.00				5x DAS 28 9-89 13-11-4			
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				[signature] 13-11-06			

[initials] 13-11-04

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
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☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
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☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-17-13 1:23:47 PM

Work Order ID: 108396

Parent Item: D2704

Parent Item Name: Cross Brace

Start Date: 10/17/13 **Required Date:** 10/17/13

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP D02.04.15Added dwg Rev.A1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	604.7329	**2.35**	**3**	SAO	13-10-30	

Location	Loc Qty	Loc Code	
MAT017	604.7329225		
118702	0.00003		
123303	138.9645		
125513	191.873653		
m126922	273.89474		15

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____ Part No. ____ NCR No. ____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

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Landing Gear	**General**			
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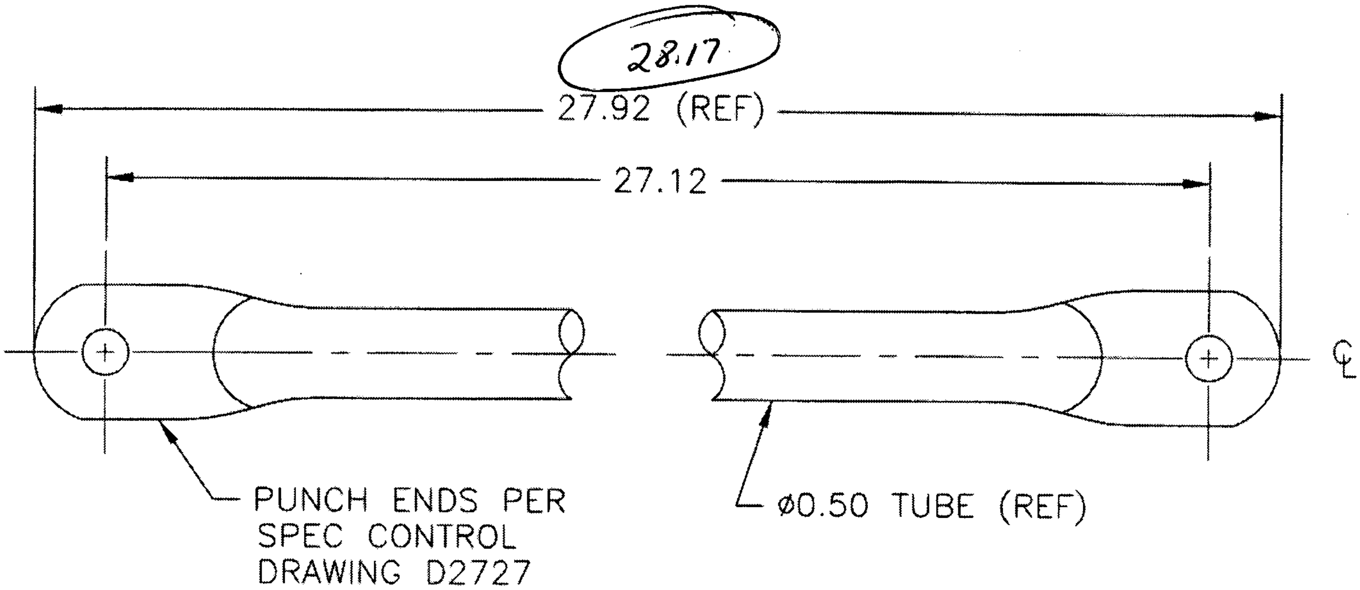
![DART]

QA COPY ISSUED

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED	DRAWING NO. D2704	REV. A SHEET 1 OF 1
DATE 98.08.24		TITLE STRUT	SCALE NTS

A		98.08.24	NEW ISSUE
A1	CP	02.03.22	ADD FINISH

RELEASED 99.11.02 KE



108396 MCS
13-10-22

MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.50 x 0.035 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 A1

DART AEROSPACE LTD

DART AEROSPACE

Description:	Cross Brace	Work Order:	108396
Inspection Drawing:	D2704 Rev: A1	Part Number:	D2704

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
27.92	+/-0.030	27.93	✓		M-T	SAD-1
27.12	+/-0.030	27.12	✓		M-T	SAD-1

Measured by: SAD	Checked By: DAS 30 9-89	QC inspector: SAD	Engineering Approval (*if necessary*):
Date 13-10-20	Date 13/10/30	Date 13/10/30	Date